

Work Order ID 144771

144771

Page 1

May 05, 2016 9:19:31 AM

Item ID: D3205-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Bracket
 Start Date: 5/4/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 5/25/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MS Date: MAY 05 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3205	Rev C								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)								
110	HAAS CNC VERTICAL MACHINING #1	1.82							
110									
HAAS 1	Memo	6.90							
HAAS CNC vertical machine #1	Machine D3205-1 as per Folio FA346 and Dwg D3205Identify as D3205-1								
	Deburr and Tumble								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.10							
Quality Control									

10 _____ 2/16-5-12
 10 0 _____ 16/05/15
 10 0 _____ 16/05/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Pedal Bracket

Start Date: 5/4/2016 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 5/25/2016 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Misidentified ☐	Past Due ☐								

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Work Order update only ☐

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Work Order ID 144771

May 05, 2016 9:19:31 AM

144771

Page 4

Item ID: D3205-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Bracket

Start Date: 5/4/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/25/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.10							DAS
Packaging	LOCATION : GA								6
									9-89
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	1.00							
Quality Control									

10 MAY 30 2016

MCS

JUN 01 2016

MAY 31 2016

MCS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

May 05, 2016 9:19:31 AM

Page 1
A

Work Order ID: 144771

144771

Parent Item: D3205-1

D3205-1

Parent Item Name: Pedal Bracket

Start Date: 5/4/2016

Required Date: 5/25/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.06.09New issueKJ/RF
IPP Rev:B 08-12-16 attach DEO DD verified by:EC
REV:C AS PER REV B 12-03-23 JLM VERIFIED BY:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased		No		100	f	8.9420	0.3646	3.837895			

M7075T73B2 500X03 25

7075-T73 Bar 2.50 x 3.25

SL 16-5-12

Location

Loc Qty

Loc Code

MAT

8.942

m131479

2.942

m134336

6

3.6

DQA: _____ Date: _____



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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

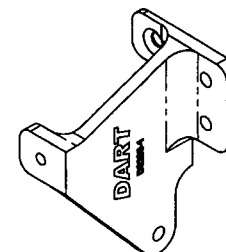
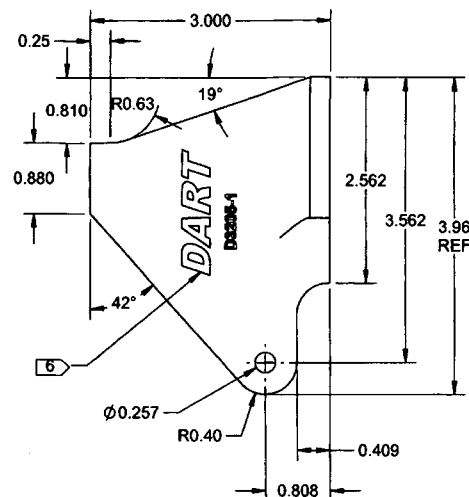
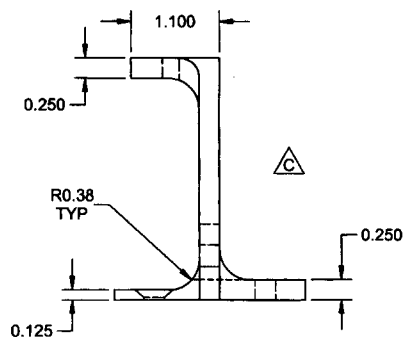
DART AEROSPACE LTD		Work Order: 144771
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.104	✓		Vern M1-06	
0.250	+/-0.010	.250	✓		"	
R0.38	+/-0.030	R.375	✓		R-6	
0.125	+/-0.010	.126	✓		Vern M1-06	
0.250	+/-0.010	.252	✓		"	
2.380	+/-0.010	2.384	✓		"	
1.380	+/-0.010	1.380	✓		"	
0.500	+/-0.010	.501	✓		"	
0.880	+/-0.010	.880	✓		"	
Ø0.470 x 100°	+0.006/-0.001	Ø.470	✓		Caliper	JCL-08
0.440	+/-0.010	.440	✓		"	
0.600	+/-0.010	.600	✓		"	
1/4-28UNF-313	N/A	✓	✓		"	
0.250	+/-0.010	.253	✓		"	
Ø0.257	+0.006/-0.001	Ø.258	✓		"	
1.750	+/-0.010	1.751	✓		"	
0.870	+/-0.010	.870	✓		"	
0.440	+/-0.010	.440	✓		"	
R0.25	+/-0.030	R.250	✓		R-6	
3.000	+/-0.010	3.000	✓		Vern M1-06	
3.96	+/-0.030	3.958	✓		"	
0.409	+/-0.010	.410	✓		"	
0.808	+/-0.010	.808	✓		"	
2.562	+/-0.010	2.562	✓		"	

Measured by: DAS 14 9-89 / S.C.V.	Audited by: DAS 33 9-89	Preliminary Approval:
Date: 16/05/15	Date: 16/06/02	Date:

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	12.05.14	Dimensions updated per Dwg Rev B	KJ	
C	13.02.27	Dwg Rev updated	KJ	



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WITHOUT NOTICE
WORK ORDER
NO 144771 ML
1605-05

RELEASE
2013-02-07

NOTES:

- NOTES:**
1) MATERIAL: 7075-T73 ALUMINUM BAR
PER QQ-A-200/11 OR QQ-A-250/12
REF DART SPEC M7075T73B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
7) WEIGHT: 0.28 lbs

C	REMOVED GRAIN DIRECTION ON -1 (ZN B5-1) SEE PREVIOUS REV. FOR DETAILS. REF. PAR12-212	SFM	12.12.24
B	CONVERT DRAWING TO STANDARD FORMAT; 3.96 WAS 3.99 (ZN C2-1)-19" WAS 18" (D3-1); 42" WAS 41" (ZN C4-1); CHANGE DIMENSIONS TO 2 DEC PL (2 D3-1, D6-1, C4-2, C4-3, C7-2); ADD CHAMFER (ZN D3-2); REMOVE ENGRAVING ON D3205-3	RF	12.02.24
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	SFM	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3205	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NT
DATE	12.12.24	COPYRIGHT © 2024 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT	

TRAINING

DART AEROSPACE LTD		Work Order: 144771
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.099				
0.250	+/-0.010	1.243				
R0.38	+/-0.030	1.375				
0.125	+/-0.010	1.123				
0.250	+/-0.010	1.247				
2.380	+/-0.010	2.380				
1.380	+/-0.010	1.376				
0.500	+/-0.010	1.501				
0.880	+/-0.010	1.876				
Ø0.470 x 100°	+0.006/-0.001	1.470				
0.440	+/-0.010	1.440				
0.600	+/-0.010	1.600				
1/4-28UNF-313	N/A					
0.250	+/-0.010	1.253				
Ø0.257	+0.006/-0.001	1.258				
1.750	+/-0.010	1.748				
0.870	+/-0.010	1.870				
0.440	+/-0.010	1.440				
R0.25	+/-0.030	1.256				
3.000	+/-0.010	3.000				
3.96	+/-0.030	3.958				
0.409	+/-0.010	1.410				
0.808	+/-0.010	1.808				
2.562	+/-0.010	2.562				

Measured by: <i>[Signature]</i> ^{DAS} 14 9-39	Audited by: <i>[Signature]</i> ^{DAS} 33 9-89	Preliminary Approval:
Date: 10-5-20	Date: 16/05/25	Date:

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	12.05.14	Dimensions updated per Dwg Rev B	KJ	
C	13.02.27	Dwg Rev updated	KJ <i>[Signature]</i>	<i>[Signature]</i>